

# Work Order ID 64423

Monday, December 06, 2010 8:53:58 AM



Page 1

Item ID:	D2230-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Lug				Stop	
Start Date:	12/6/2010	Start Qty:	80.00			
Required Date:	12/13/2010	Req'd Qty:	80.00			
Reference:						

Approvals:	Process Plan:	<i>PL</i>	Date:	<i>10-12-6</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								

100 0.00



Bandsaw  
~~Jeaspa Bandsaw~~

BAND SAW

~~Memo~~

~~Cut D2423 extrusion to 0.82"~~  
~~Batch:~~

*Cut extrusion @ meter*

0.00

110



HAAS  
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

~~Memo~~

~~1-Machine per folio FA927~~  
~~DWG REV:~~  
~~FOLIO REV:~~  
~~(Check for crack while loading into the machine.)~~  
~~2- deburr rough edges~~

*issue P10 13073*

*to meter*

*machine as per dwg D2230 REV. G*

0.00

0.00

*CL10112106 (80)*

*Purchasing*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 64423

Monday, December 06, 2010 8:53:58 AM



Page 2

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 12/6/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

~~QC2 Inspect parts off machine PA1/PA1B~~

0.00

rec'd + inspect for transit damage.

Memo

0.00

12/12/13 (80)

130



QC

Quality Control

QC6 Inspect parts - second check

0.00

Memo

0.00

S 10/12/14

count  
(x80)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

=> M 10/12/15

80 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 64423**

Monday, December 06, 2010 8:53:58 AM

Page 3

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 12/6/2010 Start Qty: 80.00

Required Date: 12/13/2010 Req'd Qty: 80.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

80 BR 10-12-15

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:15  
OVEN TEMPERATURE: 300°  
FINISH TIME: 9:45

80 BR 10-12-15

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10/12/17

80 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Work Order ID 64423

Monday, December 06, 2010 8:53:58 AM



Page 4

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 12/6/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>476</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
190	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10/12/17 80

10/12/17

ME  
10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, December 06, 2010 8:54:02 AM

Page 1

Work Order ID: 64423

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP ☐ D00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	565.8444	0.0683	5.751579			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



Location

Loc Qty

Loc Code

MAT06

565.8444265

43722

180

45800

97.8444265

63005

288

5.751579

D2230-1P

X80

*Rec'd 12/13 80*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

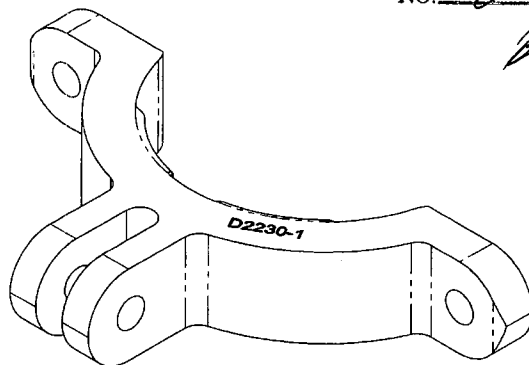
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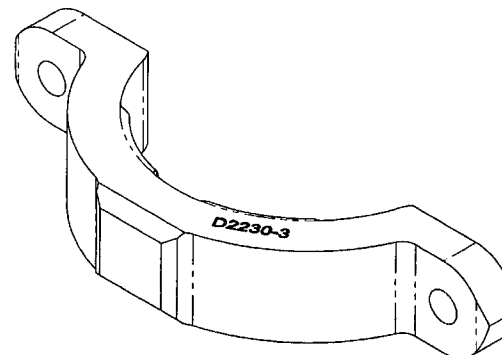
**NOTE:** Date & initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER

NO. 64423  
25-12-6



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

**RELEASED**  
*9/16/5M*

**G**

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS  
 OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
 -3: 0.14 lbs

G	REDESIGNED IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

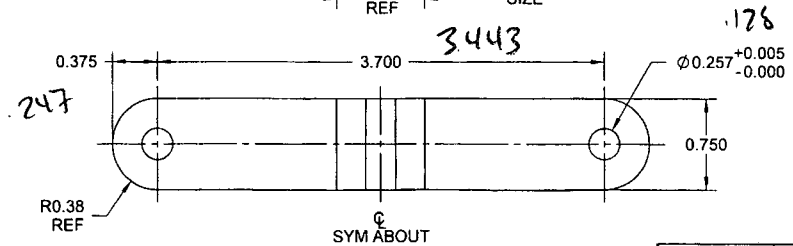
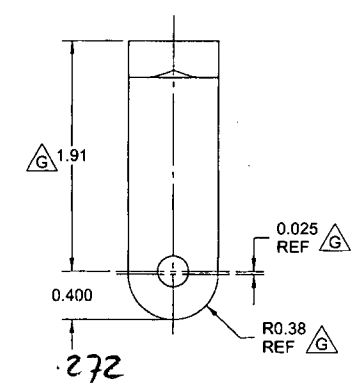
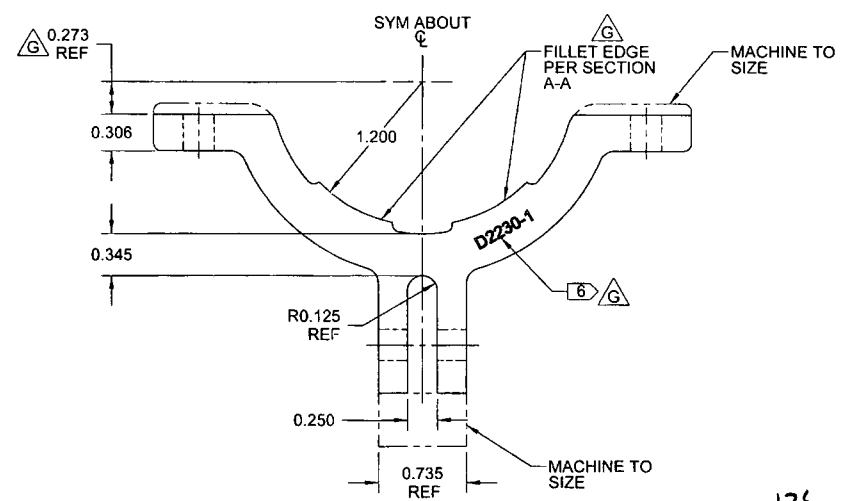
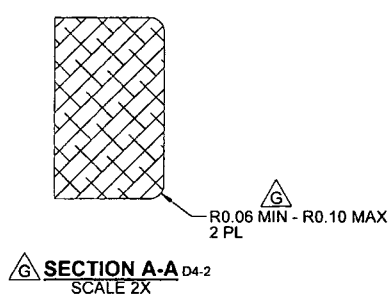
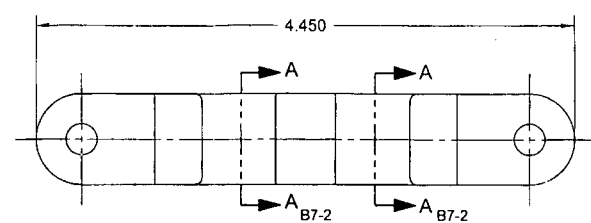
D

C

B

A

W/C 64423



**D2230-1 MOUNTING LUG**

**RELEASED**  
09/06/25/16

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D2230</b>	REV. G SHEET 2 OF 3
MFG. APPR.		TITLE <b>MOUNTING LUG</b>	SCALE NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.01.16		

~~60~~  
80

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

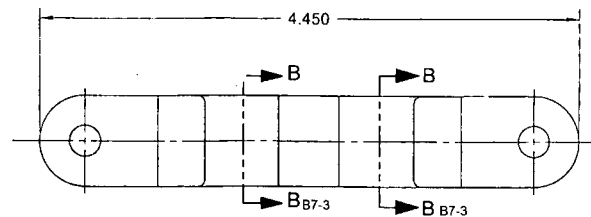
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

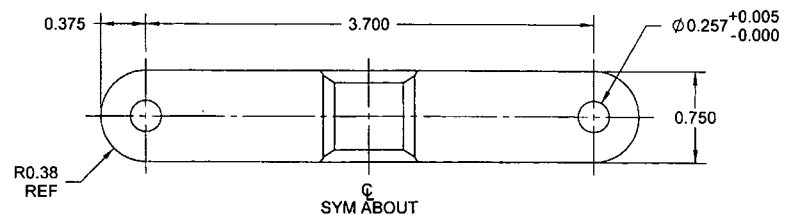
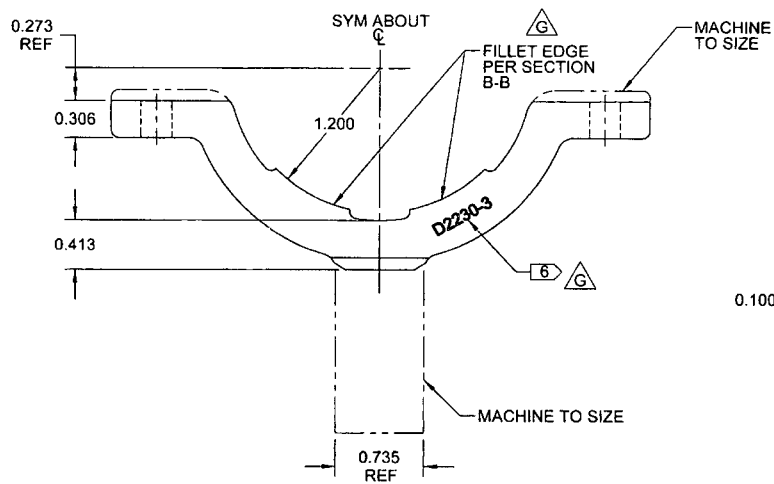
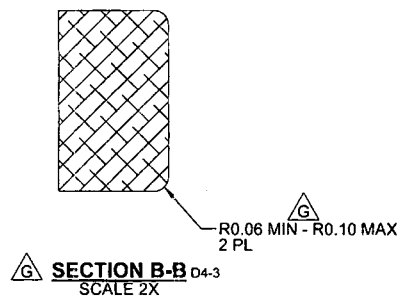
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





u/o 64423



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/23

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13073**

Purchase Order Date 12/06/10

PO Print Date 12/06/10

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, QC K0B 1R0  
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	12/17/10 Yes	80.00 Each	Yours ppd	\$18.9500	\$1,516.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B64423				
2	D2230-3P	LUG	12/17/10 Yes	80.00 Each	Yours ppd	\$10.4000	\$832.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B64422				

PO Total: \$2,348.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 12/06/10

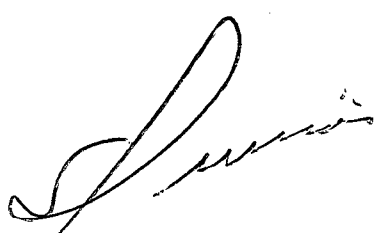
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 17620  
**Date:** Dec 10, 2010  
**Page:** 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> PO 13073	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug	Each	80	80	
D2230-3 Mounting Lug	Each	80	80	
				
Received by _____		Thank you for your order!		



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D2230-3	Mounting Lug	13000
80	D2230-3	Mounting Lug	13073
80	D2230-1	Mounting Lug	13073

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

*12/12/14*

Vankleek Hill, December 10, 2010